

Work Order ID 86068

June-20-12 12:53:19 PM

86068

Page 1

Item ID: D2596

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Web, 205 Skidtube

Start Date: 20/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/20 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2596

Rev D

100

0.00

100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Cut D2500-3-100 to length: 99.5"
2- Use Jig DT8093 to drill pilot holes #30
3- Open to 0.630" diameter as per Dwg D2596
4- Deburr

DC 12/07/25

110

Chemical Conversion Coat per QSI005 4.1

0.00

110

HandFinish

Memo

0.00

Hand Finishing

76.4 *12/07/26*

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

4 *12/07/26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2596

Accept

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Start Date: 20/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

Identify as per dwg & Stock Location: LG

0.00

130

Packaging

Memo

0.00

Packaging

4 SAD 12-07-30

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/7/30 JF

MF
12-07-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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T

Work Order ID: 86068

86068

Parent Item: D2596

D2596

Parent Item Name: Web, 205 Skidtube

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D99.02.02Changed QA to QC, Added Step 6 and CostDM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			100	Each	4.0000	1	4			

D2500-3-100

Ext'n - I' Beam Web 4"

**

Dec 12/07/25

Location	Loc Qty	Loc Code
LG	4	
51957	2	
79041	2	

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

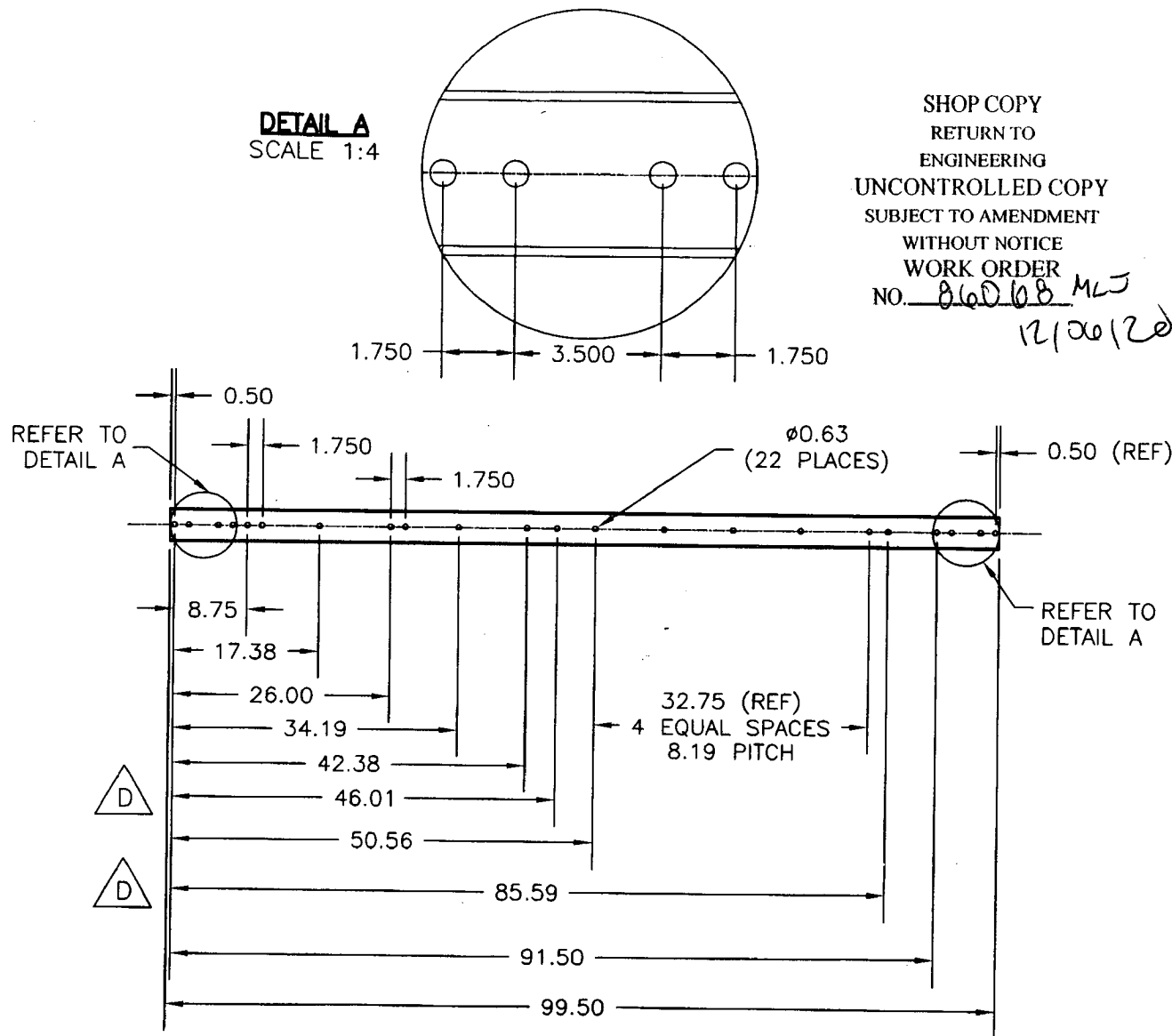
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

RELEASED
07 Dec 68

108 MLJ
12/20/20



- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

DESIGN	RA	DRAWN BY	RA	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. D
				D2596	SHEET 1 OF 1
DATE	07.04.17			TITLE	SCALE
				205 WEB	1:20
A		96.09.16	NEW ISSUE		
B		97.07.23	ø0.63 HOLE WAS ø0.56		
C		98.09.14	INCORPORATED DEO 9097		
D		07.04.17	INCORPORATED DEO 9183		

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